



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200
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D4292-1

Job Sheet 183242



Part No: D4292-1

Job Qty: 2 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	2 pcs	10/5/18	10/5/18	0.00	0.17	Bandsaw1		
110	CNC Vertical Machining	2 pcs	10/5/18	10/5/18	0.51	4.11	HAAS 5 Axis		
120	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Machining-2		
130	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-2		
140	HandFinish	2 pcs	10/5/18	10/5/18	0.00	0.11	HandFinish1		
145	Powdercoat	2 pcs	10/5/18	10/5/18	0.00	0.15	Powdercoat1		
150	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC3		
151	Small Fab	2 pcs	10/5/18	10/5/18	0.00	0.09	Small Fab-6		
152	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC5		
180	Packaging	2 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		
190	QC21-SA	2 Ea	10/5/18	10/5/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank to 6.250" ****GRAIN DIRECTION MUST BE ALONG 4.00"*****

Descriptions: 110 - 1-Machine per folio FB002

145 - MASK THREADED HOLE

151 - INSTAL HELICOIL

M. 08951 START: 19:25 OUT: 3:20 FINISH: 10:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4" Wide	1.0400 ft (.52 ea)	90-Start up Operation	519 845
MS21209F1-10	Heli Coil	2 Ea (1 ea)	151-Small Fab	5044218

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	1	27	0
151-Small Fab	MS21209F1-10	2	20	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.063Inches ± 0.010	0.073 0.053	csk	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Container No: S119846 Part: D4292 - 1 Job No: 183242 Serial No/Batch: S119846 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/19/18	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
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Description 		Disposition 												
		MRB (QSI042) Approval												
		Completed By												
		Lead hand / Supervisor Approval Verification												
		QC / QA Coordinator Approval												

Root Cause	FAULT CATEGORY																																												
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DART AEROSPACE LTD		Work Order: 183 242
Description: Fitting		Part Number: D4292-1
Inspection Dwg: D4292	Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	.063	✓		Rad gauge	
0.250	+0.030/-0.010	.253	✓		SLIO	vein
0.125	+0.030/-0.010	.125	✓			
2.95	+/-0.030	2.946	✓			
0.275	+/-0.010	.275	✓			
0.800	+/-0.010	.800	✓			
0.825	+/-0.010	.825	✓			
0.375	+/-0.010	.375	✓			
0.31	+/-0.030	.312	✓			
0.88	+/-0.030	.876	✓			
0.663	+/-0.010	.662	✓			
Ø0.381	+0.000/-0.001	.381	✓			
1.125	+/-0.010	1.125	✓			
1.063	+/-0.010	1.062	✓			
3.44	+/-0.030	3.440	✓			
2.450	+/-0.010	2.450	✓			
1.325	+/-0.010	1.327	✓			
0.300	+/-0.010	.300	✓			
1.200	+/-0.010	1.200	✓			
2.84	+/-0.030	2.835	✓			
0.19	+/-0.030	.190	✓			
5.86	+/-0.030	5.859	✓			
5.99	+/-0.030	5.991	✓			
Ø0.272	+0.006/-0.001	.272	✓			
Ø0.266	+0.006/-0.001	.267	✓			
1.75	+/-0.030	1.753	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.06	+/-0.030	.062	✓		"	
4.875	+/-0.010	4.875	✓			
0.493	+/-0.010	.489	✓			
C-bore Ø0.765	+/-0.010	.765	✓			
0.250	+0.030/-0.010	.252	✓			
0.680	+/-0.010	.678	✓			
2.250	+/-0.010	2.250	✓			
4.500	+/-0.010	4.500	✓			
R1.275	+/-0.010	1.275	✓		Rad gauge	
R0.031	+/-0.010	.031	✓		"	

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	AA